

Work Order ID 53666

November 12, 2009 8:08:52 AM

Page 1

PRELIMINARY ISSUE

Item ID: D4011-1

Revision ID:

Item Name: Clamp, Short

Start Date: 11/12/09 Start Qty: 4.00

Required Date: 11/16/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4011

B-PRELIM

0.00

0.00

0.00

0.00

0.00

0.00

100



Purchasing

Purchasing

Water jet as per Dwg D4011

Memo

Issue P/O:

Manufacture as per Dwg D4011

Supplier: G.F.I.

Material release note is required

PRE
Lim

18 9-11-12

110



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

QC2

18 9-11-12

120



QC

Quality Control

QC8 Inspect dimensions to drawing

QC8

Memo

09.11.12 (6x)

Bend as per Dwg D4011

QC 5

09/11/13

09.11.12 (4x)

(4)

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Item ID: D4011-1

Accept



Setup Start



Revision ID:

Item Name: Clamp, Short

Stop



Start Date: 11/12/09 Start Qty: 3.00



Cust Item ID:

Required Date: 11/16/09 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00	Engineering			18	09-11-12		
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL
EFFECTIVE 11-12 AUTH
RELEASED _____ DATE _____

11/09-11-27
R00324A000

Picklist Print

November 12, 2009 8:08:51 AM

Page 1

Work Order ID: 53666

Parent Item: D4011-1

Parent Item Name: Clamp, Short

Comments: IPP RevA: New issue 09.10.26 DD verified by:JLM
dwg chg Prelim-B 09.11.12 DD verified by:EC

IPP RevB:

Start Date: 11/12/09

Required Date: 11/16/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	26.3521	0.1832	3.64		



304SS sheet .080



B 9-11-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110993Q

26.3521

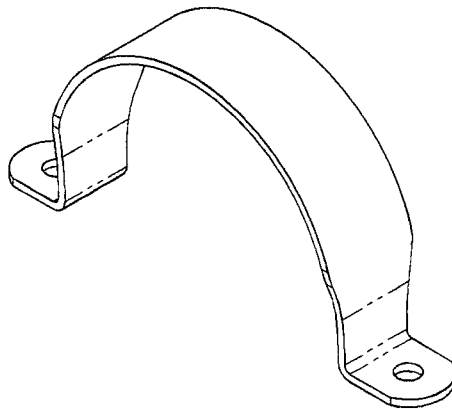
26.3521

110993

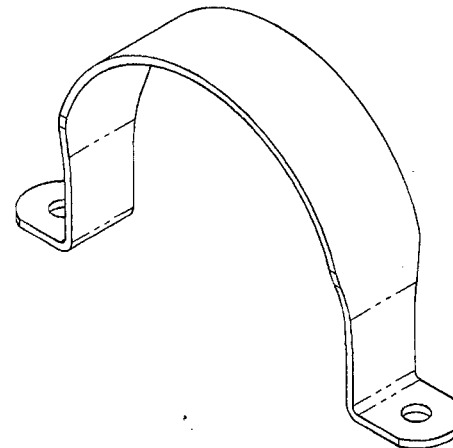
FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

also 53666



D4011-1 CLAMP, SHORT



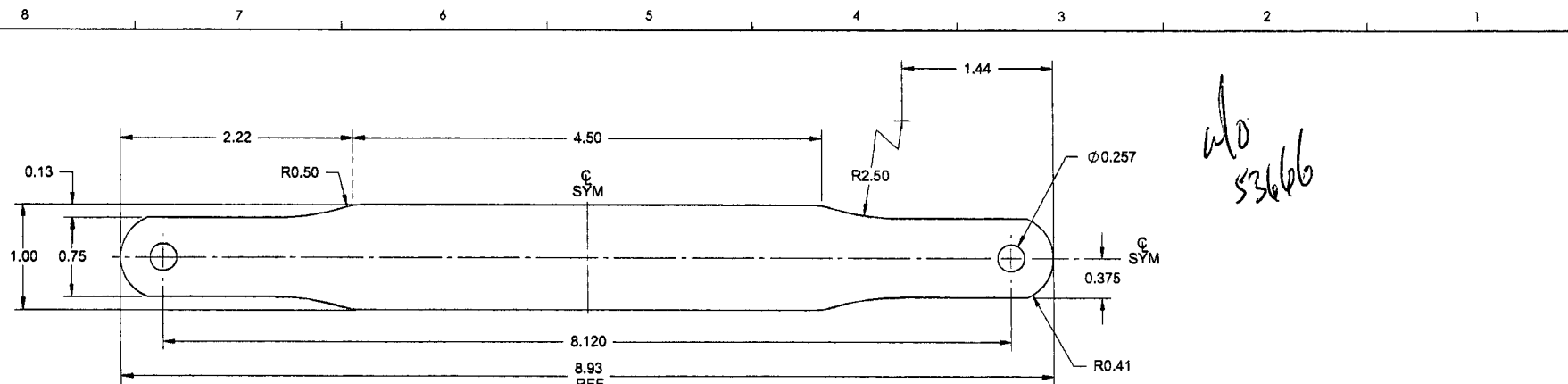
D4011-3 CLAMP, LONG

PRELIMINARY ISSUE

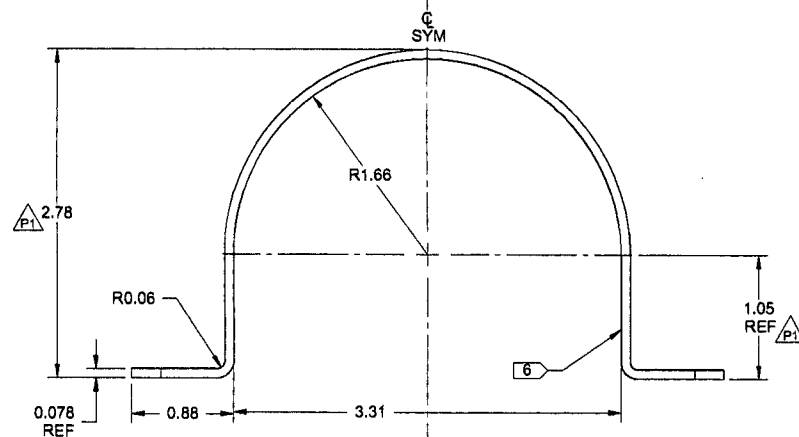
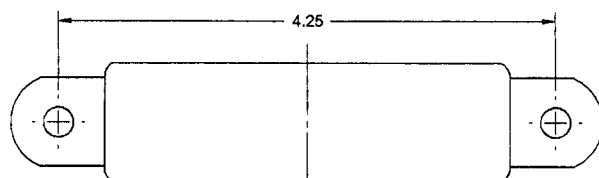
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

P1	SHORTEN HEIGHT OF -1/3 CLAMPS BY 0.125. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEW ISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.11		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. P1	
D4011		SHEET 1 OF 3	
TITLE		SCALE	
CLAMP		NTS	
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D4011-3F CLAMP FLAT PATTERN, LONG

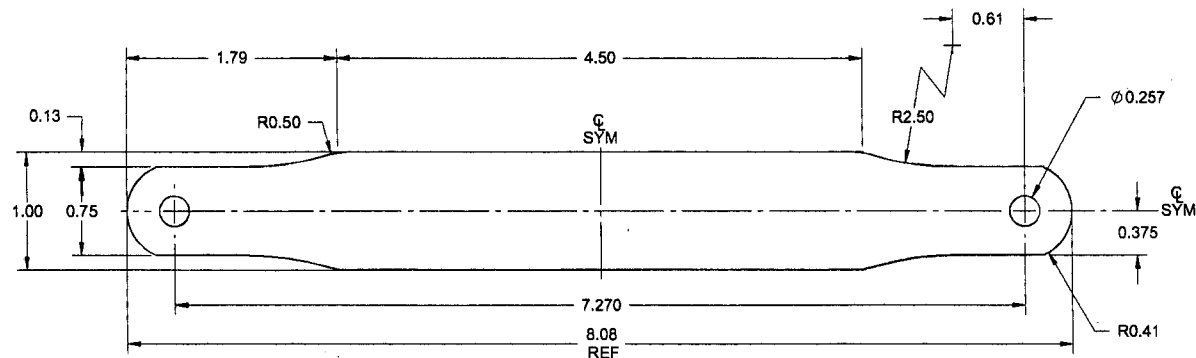


D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

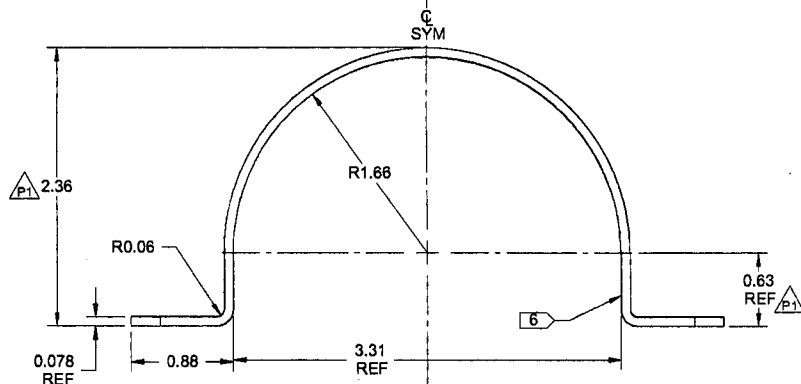
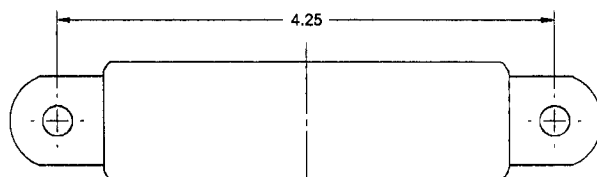
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8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)

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8 7 6 5 4 3 2 1